



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2573

Job Sheet 173589



Part No: D2573

Job Qty: 1 ea

Part Name: Saddle, Aft, Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/5/18

Job Tracking No:

Due Date: 3/7/18

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG REV F IPP: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	1 Ea	3/6/18	3/6/18	0.00	0.00	Start Up Machining		SBL 18/03/05
100	CNC Vertical Machining	1 pcs	3/6/18	3/6/18	1.01	1.67	HAAS 1		SBL 18/03/08
110	Mill Conv	1 pcs	3/6/18	3/6/18	0.00	0.17	Mill Conv 1		SBL 18/03/08
130	QC	1 pcs	3/6/18	3/6/18	0.00	0.00	QC8		S.E.L.
140	HandFinish	1 pcs	3/6/18	3/6/18	0.00	0.05	HandFinish1		SA 18-3-13
150	Powdercoat	1 pcs	3/7/18	3/7/18	0.00	0.04	Powdercoat1		BRAD 3-15
160	QC	1 pcs	3/7/18	3/7/18	0.00	0.00	QC3		11 MAR 16 2018
170	Packaging	1 pcs	3/7/18	3/7/18	0.00	0.00	Packaging3	5398 6	MAR 16 2018
180	QC21-SA	1 Ea	3/7/18	3/7/18	0.00	0.00	QC21	9-89	18/03/16

Part Op 100 - Program Batch No. _____

Descriptions: 110 - Machine keyway as per dwg D2573 & D2574

150 - START TIME: 10:45 OUT 3:00 FINISH: 11:15 M138766 21 MAR 16 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	1 Ea (1 ea)	90-Start up Operation	5047908

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	1	12	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438	438	
2	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745	1,750	
3	Saddle, Aft Outboard	3.495Inches + 0.010 - 0.000	3.505 3.495	3,500	
4	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745	1,750	

Plex 3/5/18 11:50 AM dart.leroux.jason



Container No: S047910



Part: D2573

Job No: 173589

Serial No/Batch: S047910

Revision:

Inspector:

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CANADA
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www.dartaerospace.com

Date: 03/05/18

5	Saddle, Aft Outboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990	8,000
6	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490	,500
7	Saddle, Aft Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257	,257
8	Saddle, Aft Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375	,375
9	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490	,500
10	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174	1,179
11	Saddle, Aft Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558	,568
12	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174	1,179
13	Saddle, Aft Outboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365	1,370
14	Saddle, Aft Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495	2,500
15	Saddle, Aft Outboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119	4,124
16	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115	,125
17	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115	,125
18	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240	,250
19	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115	,125
20	Saddle, Aft Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178	,188
21	Saddle, Aft Outboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210	3,230
22	Saddle, Aft Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230	,240
23	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115	,125
24	Saddle, Aft Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308	,310
25	Saddle, Aft Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760	,760
26	Saddle, Aft Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352	,362
27	Saddle, Aft Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470	,500
28	Saddle, Aft Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615	,625
29	Saddle, Aft Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053	,063
30	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240	,250
31	Saddle, Aft Outboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500	1,500
32	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115	,125
33	Saddle, Aft Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240	,250
34	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240	,250
35	Saddle, Aft Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000	2,000
36	Saddle, Aft Outboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023	,033